

Abstract:

To improve the conditions when starting up a casting operation in a two-roll casting device without the use of a start-up strand, the invention proposes a method comprising the following steps:

- setting an operating casting thickness and rotating the casting rolls at a casting-roll circumferential velocity which corresponds to a starting casting velocity, which is lower than a steady-state operating casting velocity,
- feeding metal melt into a melt space, which is formed by the rotating casting rolls and the side plates bearing against them, and forming a cast metal strip with a substantially constant, predetermined cross-sectional format while at the same time increasing the casting velocity to a strip-forming casting velocity,
- then increasing the casting velocity to a strip-separating casting velocity, which is significantly higher than a casting velocity which is sufficient for the prevailing full solidification conditions, and separating off the metal strip which has been cast thus far,
- setting a steady-state operating casting velocity,
- diverting the subsequent cast metal strip to a strip-conveying device and commencing steady-state casting operation.

(Fig. 1)